

FIG 1

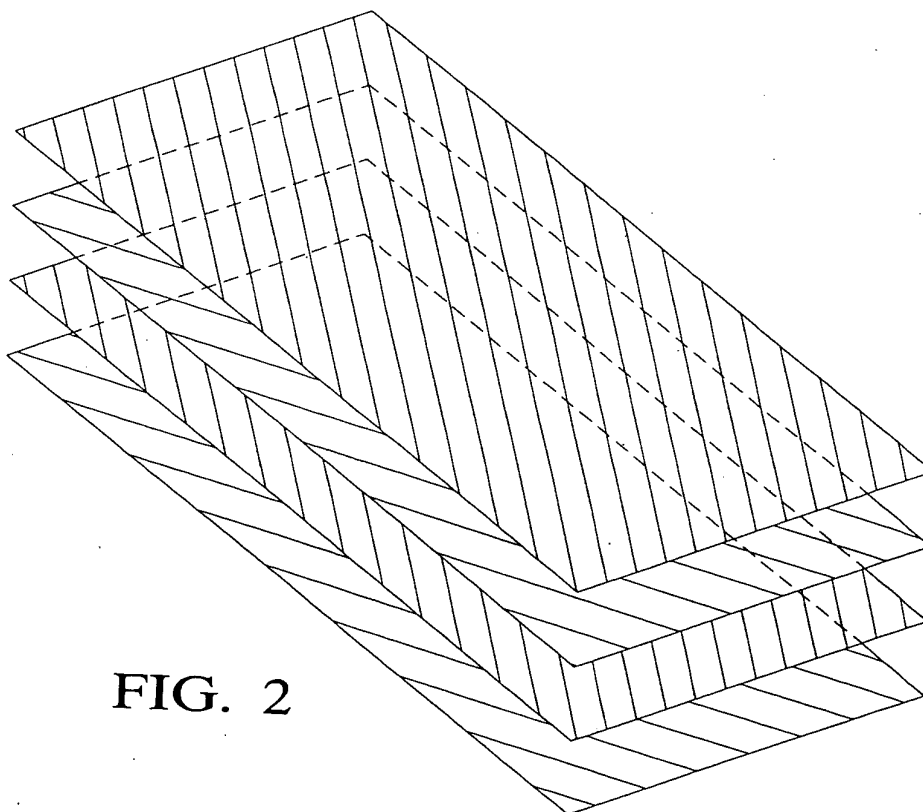


FIG. 2

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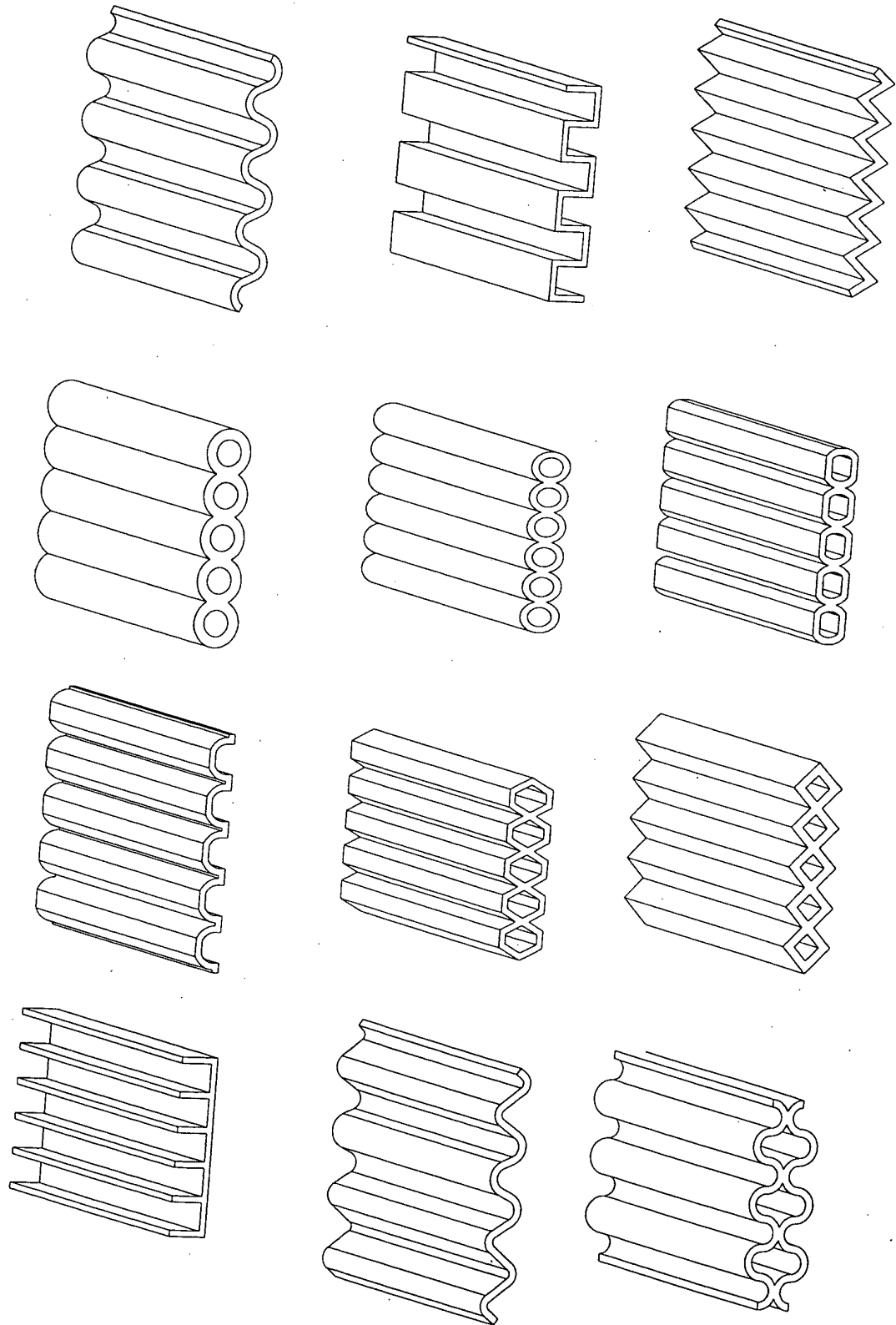


FIG. 3

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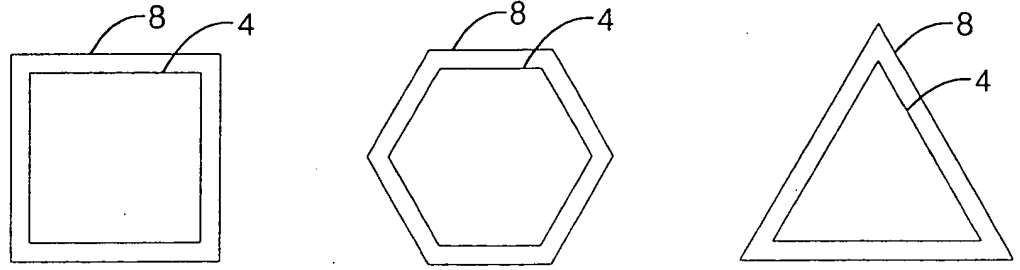


FIG. 4

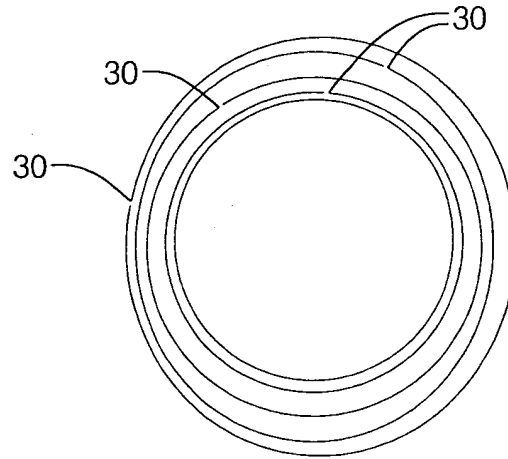


FIG. 6

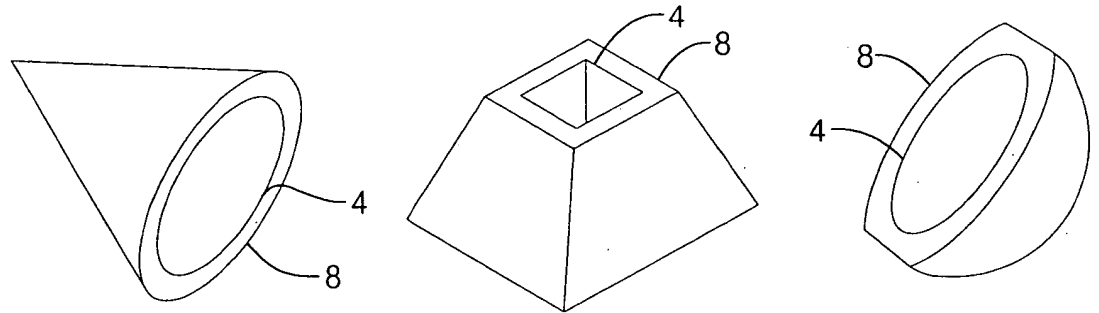


FIG. 10

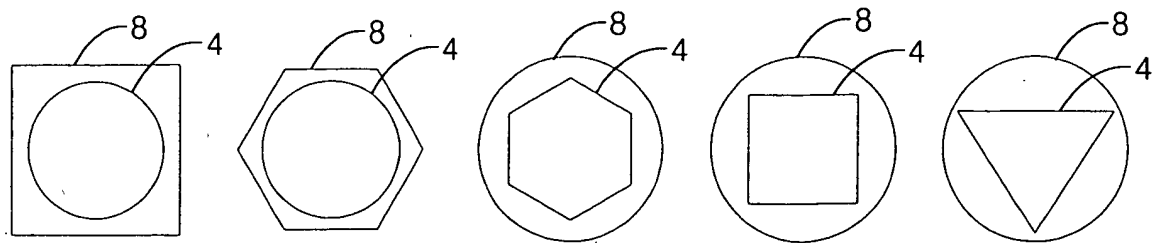


FIG. 11

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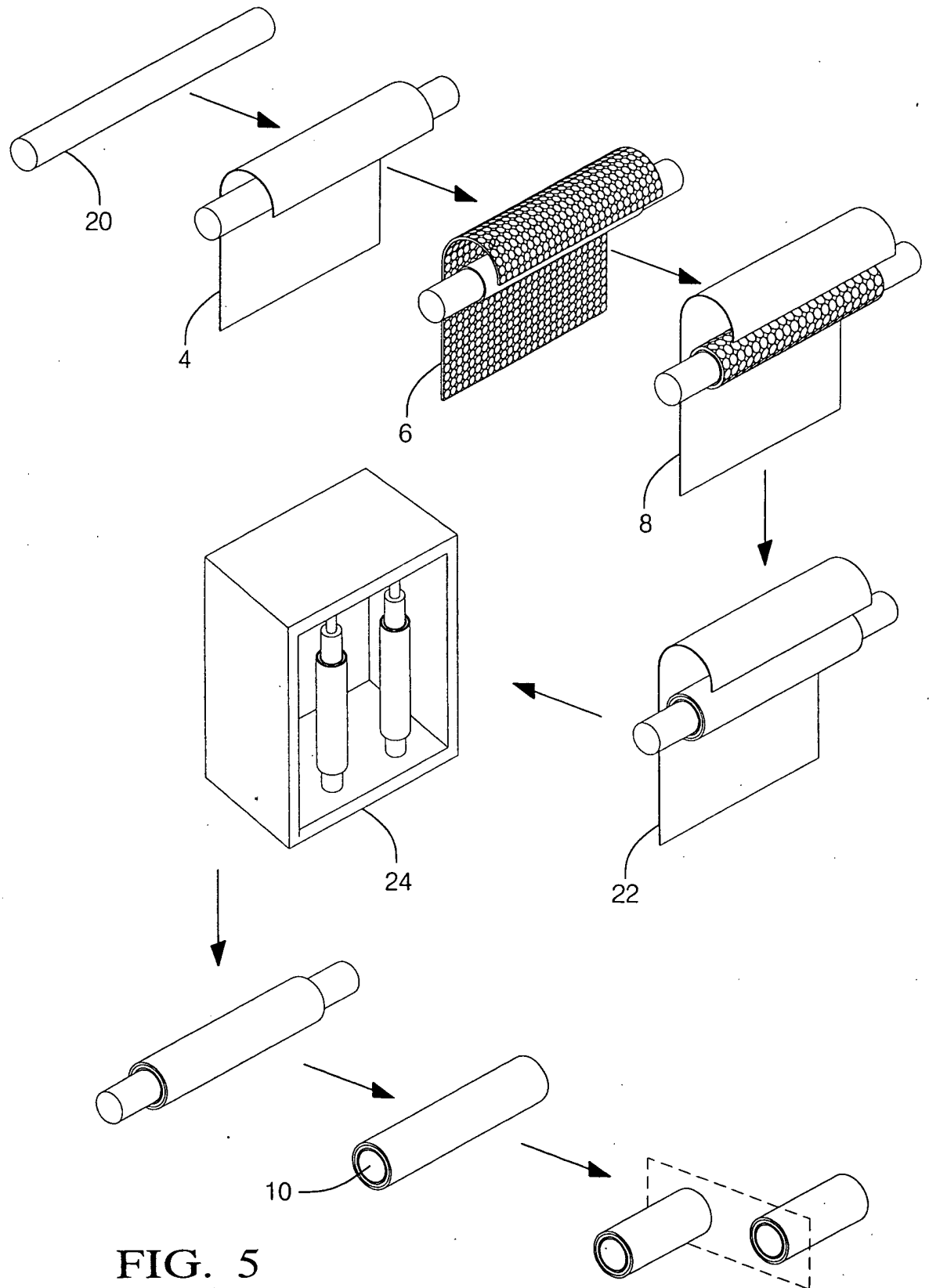


FIG. 5

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FIG. 7

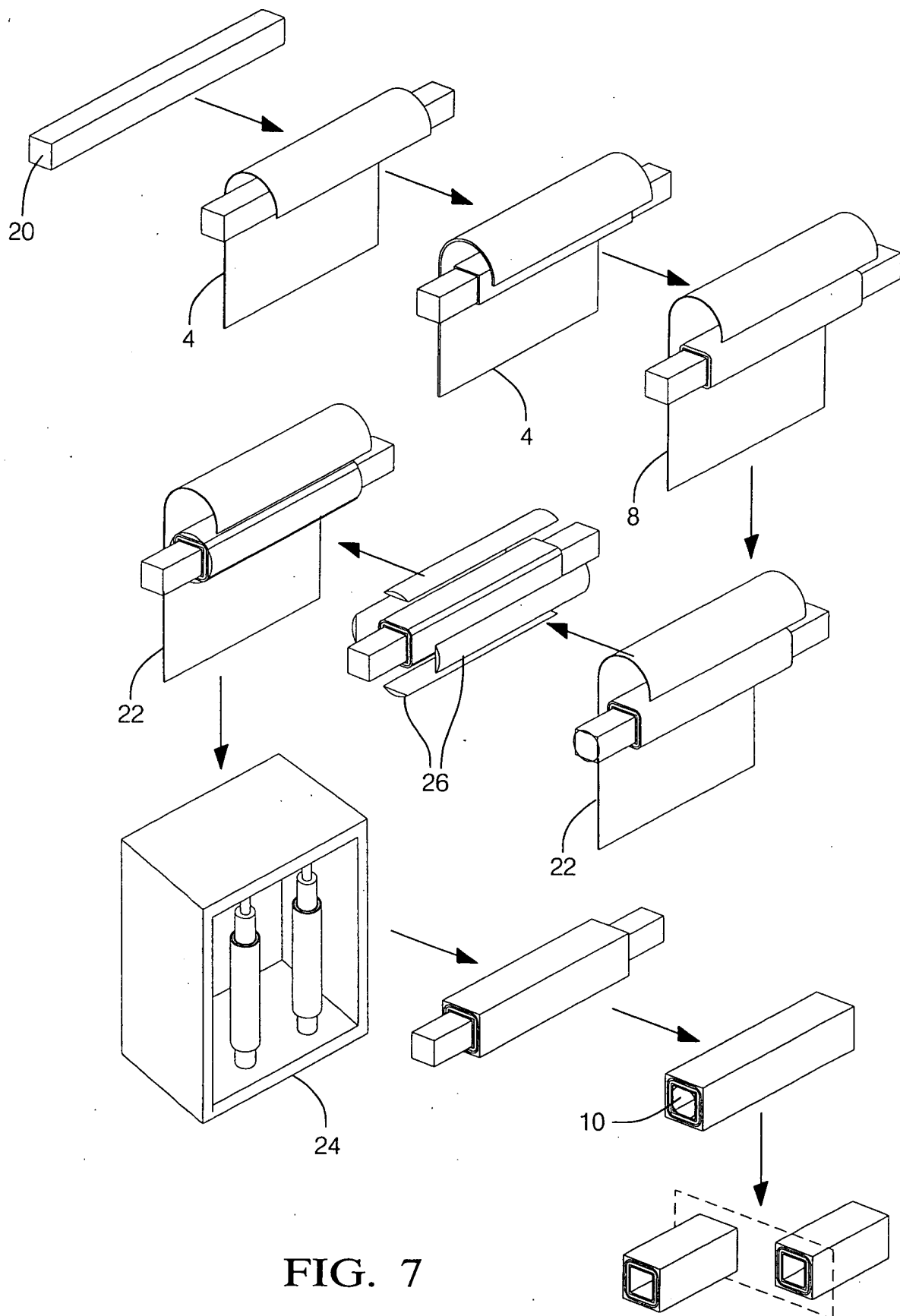


FIG. 7

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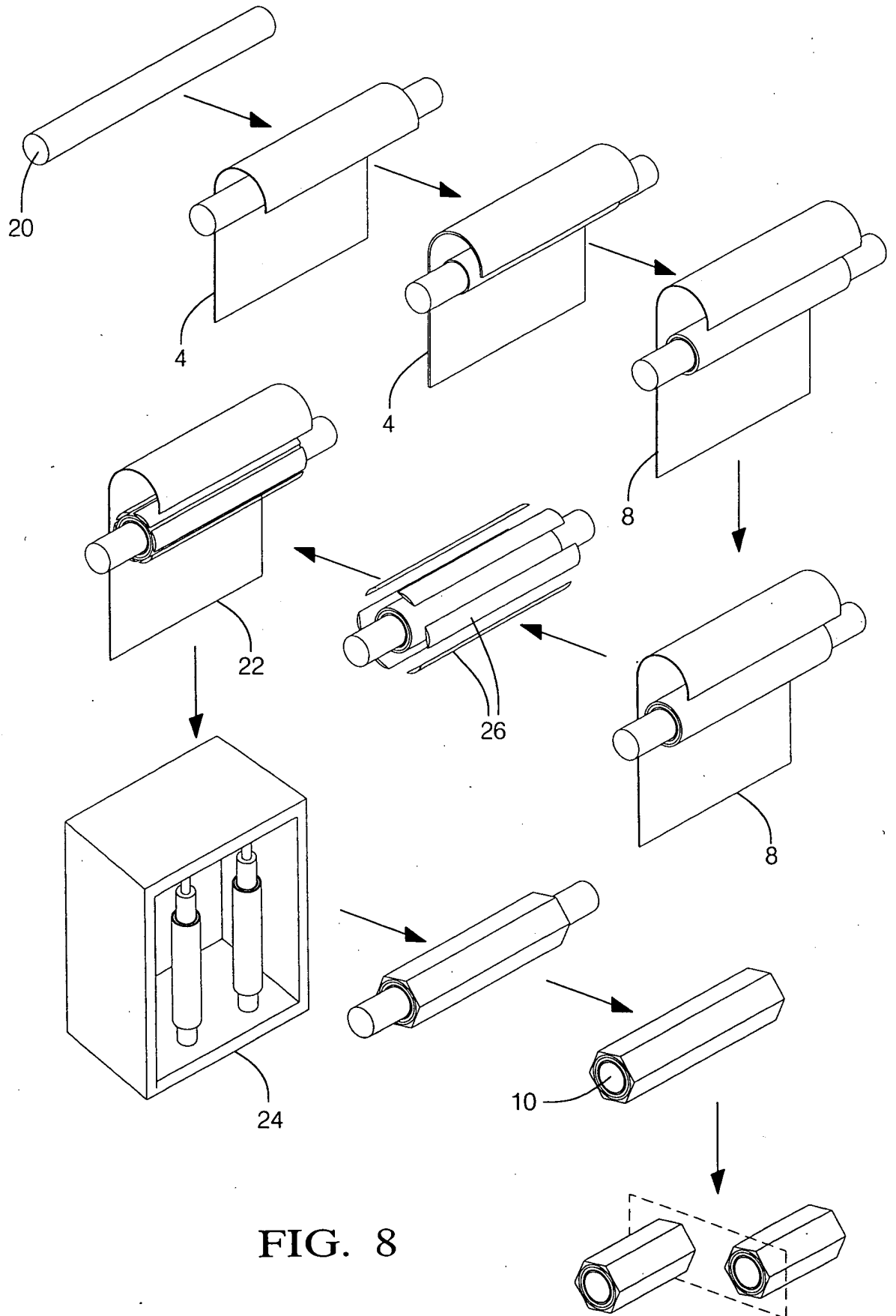


FIG. 8

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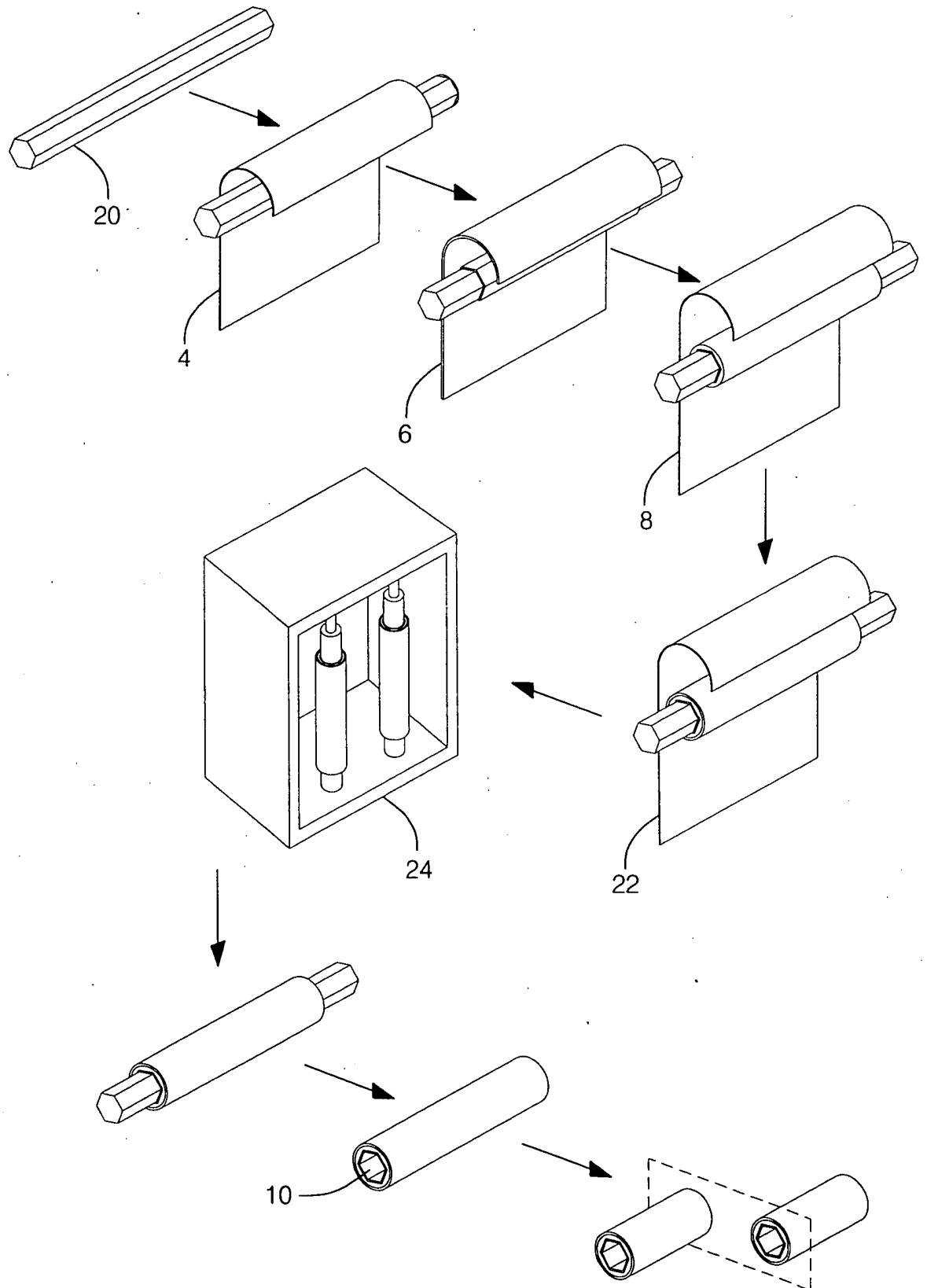
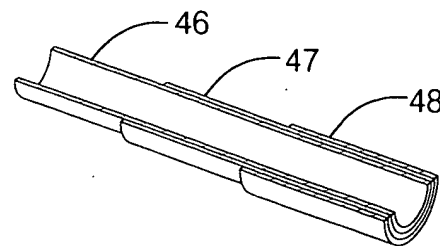
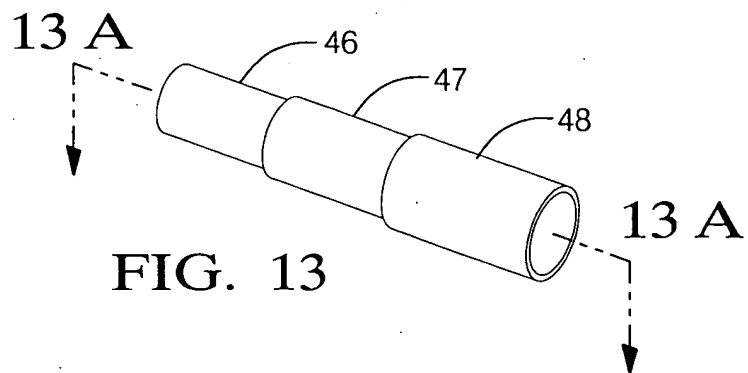
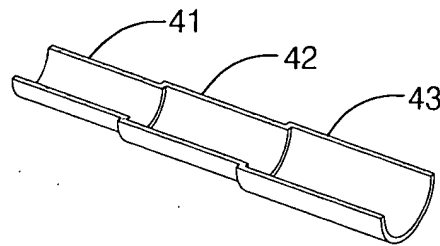
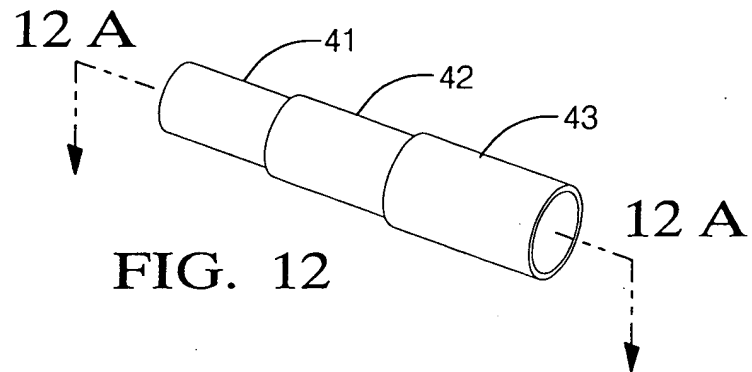


FIG. 9

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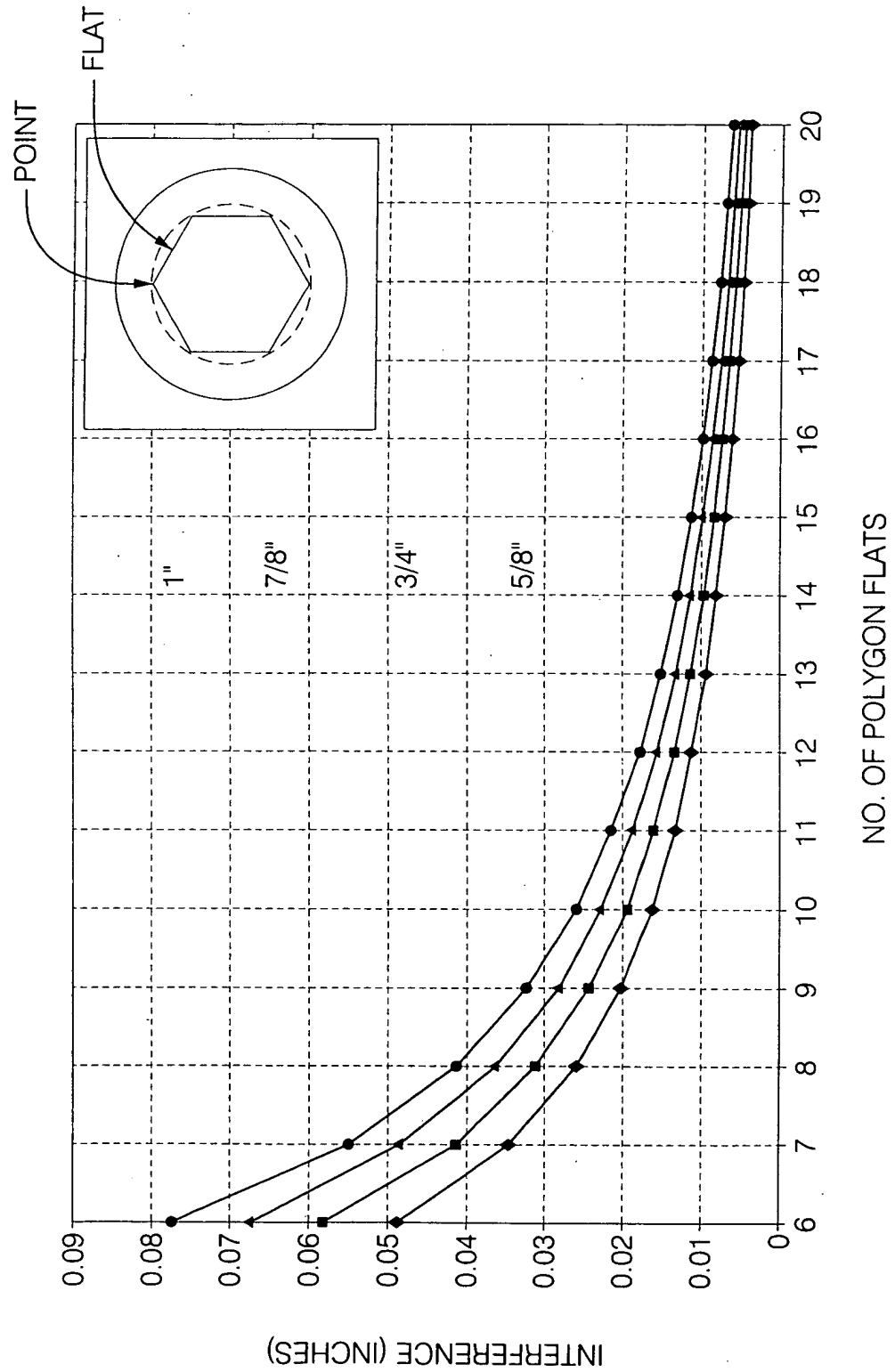


FIG. 14



FIG. 15

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COMPOSITE LAYER THICKNESS	0	3	5	10	15
10			160	260	SHAFT BROKE
12	156 169	291 304	SHAFT BROKE	304	SHAFT BROKE
14		339 291	325 351	325	STEEL BROKE
16		340 350	STEEL BROKE		
18	120		350	315	STEEL BROKE
20					
22					
24					
	0	3	5	10	15

FIG. 16

NO. OF END OVERWRAP LAYERS